

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006779**Date Inspected:** 21-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed MT of approximately 15% and VT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as West Tower Lift 3 Skin B stiffeners. The weld designations reviewed are as follows:

Bay 11

1. WSD1-FBSA3-2B/C-1A (B)
2. WSD1-FBSA3-2A/C-37A (B), 38, 39
3. WSD1-FBSA3-2B/C-2, 3
4. WSD1-FBSA3-2B/C-7A (B)
5. WSD1-FBSA3-2B/C-43A (B)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as South Tower Lift 4 Skin C. The weld designations reviewed are as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay 10

1. SSD1-FCSA4-1A/C-59, 64A/B

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 6AW. The weld designations reviewed are as follows:

Bay 14

SP121A-001-008, 009, SP148A-001-008,009, BP086A-001-12, 13, BP032-001-14, 15
LD015-007-008, LD019-003-003, LD003-011-003, LD003-012-003, LD009-004-003

Bay 10

FCAW welding of weld joint 22 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Yu Chaoye (053869). ZPMC QC is identified as Mr. Li Ming.
The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 45 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Liu Fuquan (053869). ZPMC QC is identified as Mr. Li Ming.
The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 42 located on NSD1-FDSA3-1B/C.

Welder is identified as Mr. Zhuang Hua (068206). ZPMC QC is identified as Mr. Li Ming.
The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

Bay 2

ZPMC's welding personnel Mr. Ji Yi (045268) was observed welding on various areas on OBG Segment 1AAW. QA Inspector observed that ZPMC CWI Quality Control (QC) Inspector was not present during the welding operations at noted location during the time of QA observations from 0245 to 0350.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
----------------------	------------	-----------------------------

Reviewed By:	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------